

Work Order ID 84214

84214

Page 1

May-08-12 8:36:41 AM

Item ID: D2353

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Stiffener

Stop ***NS2***

Start Date: 08/05/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 22/05/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/05/08

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2353

Rev C

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2353 Dwg Rev: C Prog Rev: C 2-
Deburr if necessary

2084 .050

6 0 Jm 12-6-14

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

6 0 Jm 12-6-14

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

Jr/ae/15

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Run

Start

NR1

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Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

NC BRAKE

0.00

130

Brake NC

Memo

0.00

Brake NC

Bend per Dwg D2353

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

8/12/06/15

(8)

(XG)

12-6-17 @

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Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
155	QC7-Inspect Chemical Conversion Coat	0.00							
155									
QC	Memo	0.00							
Quality Control									
160	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
160									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 1:45								
	FINISH TIME: 3:20								
	OVEN TEMPERATURE: 275								
170	QC3- Inspect Part Finish	0.00							
170									
QC	Memo	0.00							
Quality Control									

6X ~~Ø~~ *ML* 12/06/18

6X ~~Ø~~ *ML* 12/06/18

6Ø *BLD-618*

ML21279

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Identify as per dwg & Stock Location	0.00							
180									
Packaging	Memo	0.00							
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

6x

SP

12-6-19

12/6/19

mf 12-06-19

W/O:		WORK ORDER CHANGES					
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Picklist Print

May-08-12 8:36:45 AM

Page 1

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84214

Parent Item: D2353

D2353

Parent Item Name: Stiffener

Start Date: 08/05/2012

Required Date: 22/05/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev: A Removed from 9 Digit 05-11-10 EC
IPP: B 06.11.15 waterjet EC
IPP: c 06.12.07 ecn 836 ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.050

Purchased

No

100

sf

118.2000

0.1463

0.924

M2024T3S 050

**

Jm 12-6-14

2024-T3 .050 sheet

Location

Loc Qty

Loc Code

MAT022

118.2

117684

23.9

121216

94.3

121889

121889

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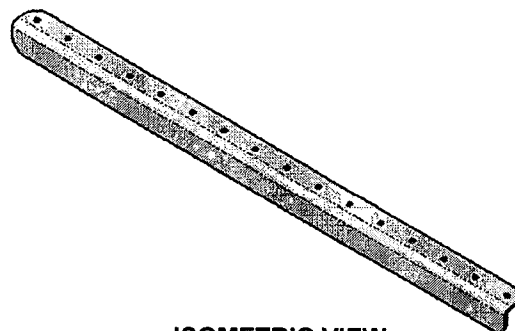
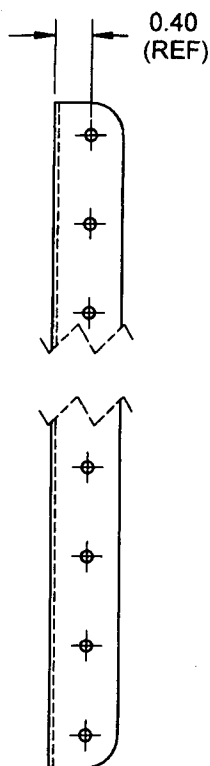
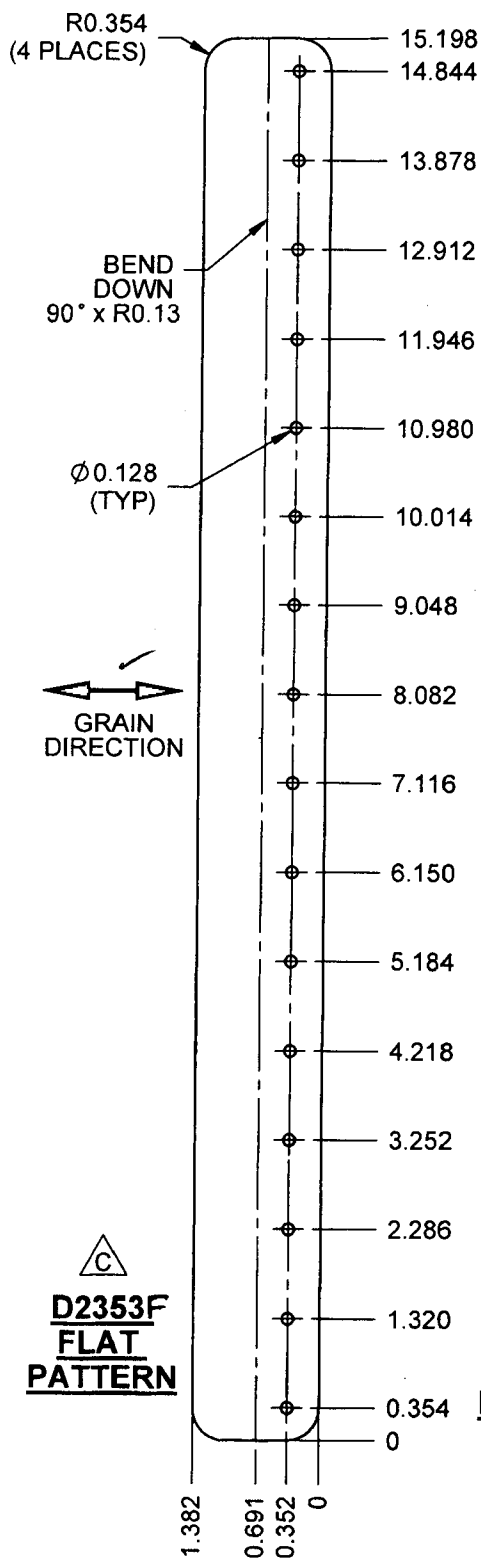
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DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D2353	REV. C SHEET 1 OF 1
DATE 06.11.13	TITLE STIFFENER	SCALE 1:2	
REV	DATE	DESCRIPTION	
B	95.02.23	ADD TEXT	
C	06.11.13	ADD FLAT PATTERN; ADD NOTES; UPDATE DWG	



- NOTES:
- 1) MATERIAL: ALUMINUM 2024-T3 SHEET, 0.050 THICK
PER QQ-A-250/4 OR AMS 4037
(REF DART SPEC M2024T4S.050)
 - 2) FINISH: CHEMICAL CONVERSION COAT
PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7)
PER DART QSI 005 4.3
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) IDENTIFY WITH DART P/N "D2353" USING A WHITE FINE POINT PERMANENT INK MARKER
 - 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

**D2353F
FLAT
PATTERN**

**D2353
BEND DETAIL**

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 84214 MLC
12/05/08
RELEASED
06-11-28 [Signature]

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